İBA KİMYA SAN. ve TİC. A.Ş.
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IBAFLASH_PN10

Technical Data Sheet

Description

IBAFLASH_PN10 is based on epoxy resins and phenolic hardeners and is especially designed for the primer coating of metallic items prior to aluminium vacuum metallization. It provides outstanding flow-out and good adhesion of the metallization.

Characteristics

High Tg of the cured film
Perfect stability of the aluminium layer at operation temperature

Applications

Clearcoat primer for the parabolas
Primer for glass bottles coated with metallization

Product Properties

UV Resistance	Not recommended for exterior use.
Flow out	Very good
Surface	Gloss GL
Specific gravity	1.2-1.3 gr/cm^3
Shelf Life	12 months (< 30°C and < 50% RH)

Application Data

Application	Corona/Tribo (Can be applied by tribo guns if product code has “T” for the 6th character)
Curing	240°C 20 minutes recommended
Film Thickness	60-80 µm (recommended)

Theoretical cons. 9-12 m^2/kg. Practical spreading rates will vary due to such factors as method and conditions of application, specific gravity, surface profile and texture.

Coating Properties

Colour	Dark brown transparent
Gloss	>100 gloss (60°)

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Application Guide

Surface Preparation
All surfaces should be degreased and pretreated for optimal performance.
Suitable pretreatment includes:

Aluminium	Yellow chromate or green chromate/phosphate
Ferrous metals	Zinc phosphate or Iron phosphate
Zinc Coated Metals	Tricatioinic phosphate or chromate

Application Procedure and Equipment
IBAFLASH_PN10 series powder coatings charging properties are optimized when powder is free-flowing and moisture-free. Aged or compacted powder may require preconditioning for several minutes to fluidise evenly.
If storage room temperature is lower than the application area, powder coatings, which are hygroscopic, should be acclimated in unopened containers prior to adding into the spray hopper. For optimum performance, It should be applied and stored at air-conditioning area. Storage temperatures should be kept below 30°C.
Powder should not be stored in hoppers for long periods of time. If moisture condensation occurs, fluidize powder to dry-out or replace moisture-laden powder with virgin powder.
Powder coatings are finely ground particulates. Respirators or dust masks should be used by workers exposed to powder in order to avoid dust inhalation.
Compressed air to the gun must be oil and moisture free.
Silicone should not be used in application area.
For box feeders, ensure probe is fully inserted in powder and operated as per manufacturer's recommendations.
Contact points should be maintained to ensure metal-to-metal ground.
Apply by electrostatic spray. Relative humidity should be 50-60% for corona system, lower than 40% for tribo system.
Cure as per recommendations outlined above.
Reclaim-to-virgin ratios should be carefully monitored to maintain spray consistency.
Sieving powder before adding to hopper eliminates potential clumping or foreign matter.

Stability of Subsequent Coatings

IBAFLASH_PN10 is designed to receive a metal reflection topcoat like e.g. aluminium vacuum metallization. Due to its highest crosslinking density the film is very stable at high temperature.

Health and Safety

The SDS is an integral part of using this product as it contains information on the potential health effect of exposure, personal protective equipment needed. It is recommended to contact to Sales and Customer Service Offices for further information.

Precautions and Limitations

As a result of possible wide application variations and stoving conditions, IBAFLASH_PN10 may show variation, between İBA Kimya Powder Coatings prepared samples and production applied material. Therefore, it is the applicator and/or their customer's responsibility to ensure the product conforms to their requirements.
Due to its outstanding flow-out and substrate wetting properties IBAFLASH_PN10 is sensitive to the presence of oils, greases and other impurities. In order to avoid pinholes, craters or any other surface failures it is absolutely necessary to apply on thoroughly degreased and chemically treated substrates.
Not recommended for exterior applications.

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Transport and Storage

Packaging	15-20 kgs. Heavy polyethylene bag in a corrugated carton
Shipment	Not dangerous goods. No special transport requirements.
Storage Conditions	Storage temperatures should be kept below 30 C° and 50% relative humidity. Powder should be stored in closed containers.

DISCLAIMER: All the information provided in this data sheet depends on our knowledge and experience up to date and may be subject to revision as new technology and experience evolve. Since the conditions of application may vary depending on the substrate, physical conditions and other variables, users should conduct necessary tests to determine the conformity of the product for its intended use. We do not accept liability since the application, use and processing of the products take place beyond our control and supervision. Moreover, our liability for breach of warranty is exclusively limited to replacement of the product or refund of its price and we are not liable for incidental, indirect or consequential damages under any circumstances.